

METHOD AND DEVICE FOR PRODUCING NOZZLE-TYPE
 OPENINGS IN SPRAY ARMS FOR DISHWASHER MACHINES

The invention relates to a method and device for producing
 5 nozzle-type openings in spray arms for dishwasher machines.

In known methods and devices for producing nozzle-type
 openings in spray arms for dishwasher machines the spray
 arms comprised of plastic are produced by means of a so-
 10 called extrusion blowing procedure, i.e. a granulate or
 pulverulent plastic is plasticised in a thermal method and
 this highly viscous mass is then put into a corresponding
 form by a moulding tool. Because the spray arms are
 15 designed hollow, a hose produced according to the
 abovedescribed extrusion process is utilised as starting
 body for producing the spray arms, which is heated to a
 certain temperature and in this deformable state is pressed
 by a corresponding blowing procedure into a cooled profile
 tool. The resulting spray arm blank exhibits all the
 20 features of the finished spray arm, including the recessed
 nozzle-type openings, which must be produced in a second
 manufacturing step.

Because the nozzle-type openings are openings, it is
 25 currently not possible to produce the nozzle-type openings
 during the extrusion blowing procedure. For this the
 regions of the spray arm blank, provided for the nozzle-
 type openings, are designed as so-called domes, which must
 be removed or respectively processed in a further
 30 manufacturing process.

In conventional terms the spray arm blanks for producing
 the nozzle-type openings are subjected to a cutting or
 35 machining process, whereby the nozzle-type openings are
 made by means of cutters or milling heads, i.e. finger

millers and/or spiral borers, for example in that the projecting domes are excised or milled off.

5 Conventional methods method for producing nozzle-type openings in spray arms are therefore cost-intensive and require subsequent processing devices in which the spray arm blanks must be clamped, which undergo a certain wear and subsequently maintenance.

10 It has also proven disadvantageous that variations of the nozzle-type openings in the spray arms make refitting the reworking devices necessary, since in particular each form of the nozzle-type openings is of decisive importance also as the angle of the nozzle duct for operation of the spray
15 arm, though refitting and adapting the reworking devices is time-intensive, mechanically demanding and cost-intensive. An additional outcome is time and cost-intensive expenditure for test runs of the devices and mould production of the spray arms.

20 The object of the present invention is therefore to provide a device and a method for producing nozzle-type openings in spray arms for dishwasher machines, which enables the form of the nozzle-type openings in spray arms to alter rapidly
25 even if only one spray arm is provided and enable different nozzle geometries to be created during the production process in the event of different spray arms.

This task is solved by the inventive method having the
30 characteristics according to Claim 1 and by the inventive device having the characteristics of the other independent claim. Advantageous further developments of the present invention are characterised in the sub-claims.

35 With the inventive method for producing nozzle-type openings in spray arms for dishwasher machines nozzle-type openings of differing shape are cut out by laser from the

surface of the spray arm blank after the spray arm blank has been produced.

5 With the inventive use of laser it can be guided such during this excising of the nozzle-type openings that the walls of the nozzle duct are designed such that there are desired, and not unnecessary, turbulence of the emerging spray stream in the vicinity of the nozzle exit, i.e. the flow behaviour of the spray stream can be adjusted by
10 corresponding use of the behaviour of the spray stream by corresponding use of the laser. Because the nozzle-type openings are sharp-edged e.g. this can create constriction of the discharge stream, determined by the discharge quantity u . The result of this discharge quantity u is an
15 increase in the nozzle cross-section surface, by which blockages or contamination of the nozzle-type openings are prevented.

The openings can advantageously have different forms, which
20 deviate from a circular form, such as for example ellipsoid, corrugated, rectangular, rhombic etc.

In a preferred variant of the inventive method the laser for excising the nozzle-type openings can be shifted and
25 pivoted slightly in its position, so that not only can the form of the nozzle ducts be designed variously, but also the nozzle duct as such can have different angles of inclination.

30 The inventive device for carrying out a method for producing nozzle-type openings has a device for fixing the spray arm blank and a correspondingly positionable laser, arranged on the fixing device such that the surface of the spray arm blank can be fitted with nozzle-type openings.

35 The advantage of the inventive device is that the laser used to cut out the nozzle-type openings is configured to

vary slightly in its position to the surface of the spray arm, so that different patterns for the arrangement of the openings can be made after short set-up times or respectively reprogramming times.

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It is of particular advantage here that no mounting of the laser is to undergo any mechanical force and thus a device can be selected, which is cost-effective to produce.